



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 170370



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 2/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV:B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-2-13
100	Large Fab	1 pcs	2/17/18	2/17/18	0.00	10.00	Large Fab 1		C.C 18-2-16
110	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC9		CPL
120	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC5		CPL
125	HandFinish	1 pcs	2/17/18	2/17/18	0.00	0.29	HandFinish2		SA 18-03-16
130	Powdercoat	1 pcs	2/17/18	2/17/18	0.00	0.93	Powdercoat2		BR 18-2-16
135	Packaging	1 pcs	2/17/18	2/17/18	0.00	0.00	Packaging1		W 18-2-24
140	QC	1 pcs	2/17/18	2/17/18	0.00	0.00	QC3		W 18-2-20
150	HandFinish	1 pcs	2/19/18	2/19/18	0.00	0.50	HandFinish4		W 18-2-22
160	QC	1 pcs	2/19/18	2/19/18	0.00	0.00	QC5		W 18-2-22
170	Packaging	1 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3-2		W 18-2-27
180	QC21-SA	1 Ea	2/19/18	2/19/18	0.00	0.00	QC21		21 FEB 2 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ****take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 130467. START: 1:25. O.V.F. 375°. FINISH: 1:40.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581-5033599	2	18	0	0
	D3913-1503274/	1	4	0	0
	D3913-15031377	1	8	0	0
	D3913-35032655	1	7	0	0
	(K) 5038519 → D3913-75009710(Q)	2	15	0	0
	D3913-95030824	1	14	0	0
	D3916-0415036892	2	4	0	0
	-5037859 → D3916-55030859	3	16	0	0
	D4016-15036080	3	5	0	0
	D4017-75031312	3	45	0	0
	D4017-95038112	2	16	0	0
	D4020-11-5041136	2	12	0	0
	D4021-15039317	3	23	0	0

001013

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

150-HandFinish	D4034-041	SO39774	1	4	0	0
	D4034-043	SO39773	1	5	0	0
	D4672-1	SO36907	2	15	0	0
	M304EX0.75-16F	SO34149	33	574	0	0
	AN3-10A		6	189	0	0
	D2931		2	1,166	0	0
	D4021-5	SO43721	2	25	0	0
	MS20600-AD4W3		2	203	0	0
	MS21042L3		6	3,011	0	0
	NAS1149F0332P		12	5,455	0	0

Part Specifications

Specifications could not be found.

001013

Plex 1/15/18 2:26 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order:	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
		QTY Effective :			MRB (QSI042) Approval	
		Disposition				Completed By
						Lead hand / Supervisor Approval Verification

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DART
 AEROSPACE
S041858



Long Basket Base Assembly, 350

PART NO: D3913-041
Original Serial #: S041858
Revision:
Operation: Start up Operation 02/13/18
Change No: Job No: 170370

ic
ave

Master Unit 000608



Job No 170370

Substitution	Process Improvement	Marks/Chatter
Past Expiry Date	Manufacturing Process	
Misidentified	Past Due	OTHER :



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Master Unit 001013

Tel (613) 632-5200

Containers on Master Unit 001013				
Serial No	Part No	Customer Part No	Status	Quantity
S043575	AN3-10A	AN3-10A	Allocated	6
S043574	D2931	D2931	Allocated	2
S043576	MS20600-AD4W3		Allocated	2
S043573	MS21042L3	MS21042L3	Allocated	6
S043577	NAS1149F0332P		Allocated	12

D1021-S x2